

Work Order ID 113173-2

February-12-14 8:48:39 AM

Page 1

ASK
SPLIT

Blue
113173

Slp Mach 17

Item ID: D3414-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 2/10/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/10/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 11-02-14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID:
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

24 0 Jm 14-03-1

24 0 Jm 14-03-1

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Page 2

Item ID: D3414-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 2/10/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 2/10/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				24 cont			
130 *130* Brake NC Brake NC	Memo 1-Deburr 2-Form using DT8254 as per Dwg D3414	0.00 0.00				24			14/03/03
140 *140* Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: 120854	0.00 0.00				(5)			14-03-05 JBL

DAS
30
9-89

1. The first of these is the fact that the system is not in equilibrium with the environment. The system is in a state of constant flux, with energy and matter being constantly exchanged with the surroundings. This is a fundamental characteristic of all living systems, and it is this flux that allows them to maintain their structure and function over time.

2. The second point is that the system is not homogeneous. It is composed of many different parts, each of which has its own internal structure and function. These parts are organized into a hierarchy, with the simplest components at the bottom and the most complex at the top. This hierarchy is what gives the system its overall structure and function.

3. The third point is that the system is not static. It is constantly changing, with new components being added and old ones being removed. This is a process of continuous evolution, and it is this evolution that allows the system to adapt to its environment and to maintain its structure and function over time.

4. The fourth point is that the system is not isolated. It is constantly interacting with its environment, and these interactions are what give it its overall structure and function. The system is a part of a larger whole, and it is this whole that determines its behavior and its fate.

5. The fifth point is that the system is not deterministic. Its behavior is not predictable, and it is this unpredictability that allows it to adapt to its environment and to maintain its structure and function over time. The system is a complex, dynamic system, and its behavior is the result of many different factors interacting in a non-linear fashion.

6. The sixth point is that the system is not self-sufficient. It requires a constant input of energy and matter from its environment, and it is this input that allows it to maintain its structure and function over time. The system is a dependent system, and its survival depends on the availability of these resources.

7. The seventh point is that the system is not self-organizing. It does not have the ability to organize itself into a structured, functional system. It is the result of external forces acting on it, and it is these forces that give it its overall structure and function.

8. The eighth point is that the system is not self-replicating. It does not have the ability to reproduce itself, and it is this inability that allows it to adapt to its environment and to maintain its structure and function over time. The system is a unique system, and its existence is a result of a series of chance events.

9. The ninth point is that the system is not self-destructive. It does not have the ability to destroy itself, and it is this inability that allows it to adapt to its environment and to maintain its structure and function over time. The system is a resilient system, and its survival is a result of its ability to withstand external forces.

10. The tenth point is that the system is not self-aware. It does not have the ability to think or to feel, and it is this inability that allows it to adapt to its environment and to maintain its structure and function over time. The system is a non-conscious system, and its behavior is the result of physical and chemical processes.

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Run	Start	*NR1*
	Stop	*NR2*

FINISH TIME

5 0 0 18
14-3-14

300

300

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Item ID: D3414-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 2/10/14 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 2/10/14 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish QC14 Memo	0.00 0.00						14-03-15	(5)
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PMP 114753	0.00 0.00						14/3/17	(5)
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14-03-17	

14-03-17

Picklist Print

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Work Order ID: 113173

Parent Item: D3414-041

Parent Item Name: Lug

113173

D3414-041

Start Date: 2/10/14

Required Date: 2/10/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA

Purchased

No

100

sf

124.6300

0.155

4

M304S12GA

304/316 0.100" Steel

**

7m14-03-1

Location

Loc Qty

Loc Code

MAT019

124.63

113062

76.13

113077

19

m126309

29.5

126309

D3414-3

Manufactured

No

140

Each

48.0000

1

24

D3414-3

Lug

**

14-03-05

Location

Loc Qty

Loc Code

WA001

48

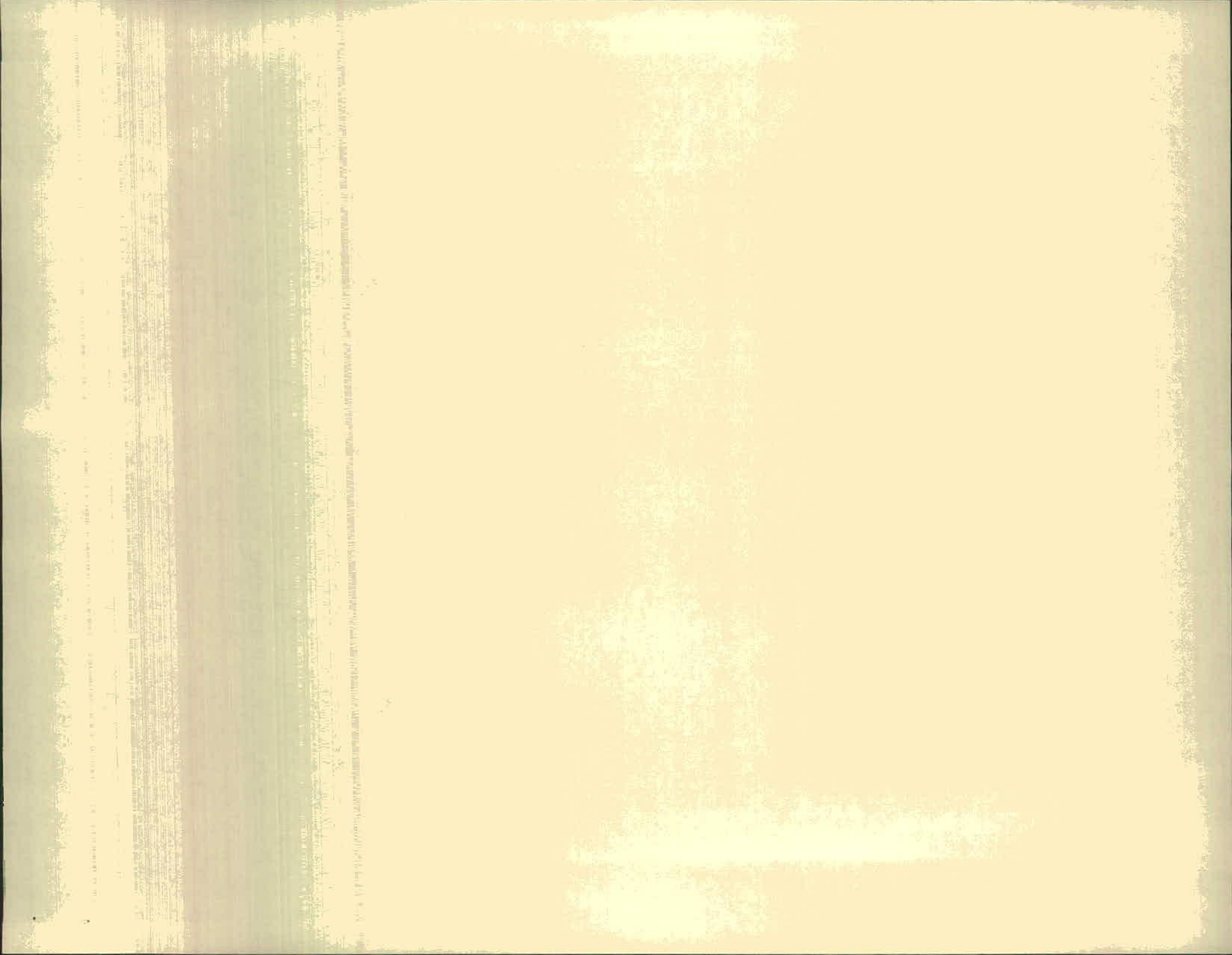
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8

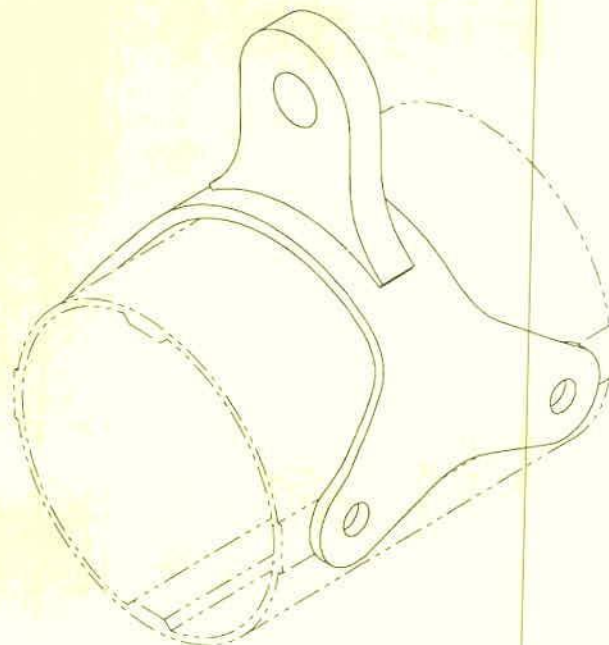
111462

40

5



ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

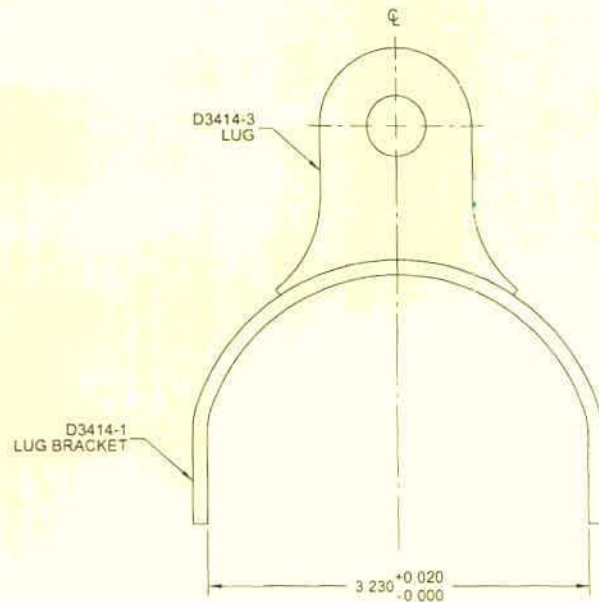
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

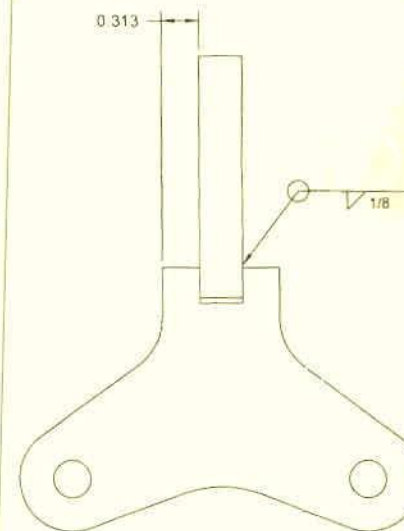
113173 MJS
14-02-14

RELEASED
8/16/05/04

C	BREAK SHARP EDGES FOR .3 NOW 0.030-0.060 WAS 0.010-0.030 (ZNA7.3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR .1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 198). FLAT SPOTS REMOVED FROM .1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7.3 ADDED TOLERANCE TO 3.230 DIM C2.3.1.12 DIM WAS 1.20	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	J	DRAWING NO.	REV. C
MFG APPR	ED	D3414	SHEET 1 OF 3
APPROVED	W	TITLE	SCALE
DE APPR	W	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE DISSEMINATION OF INFORMATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

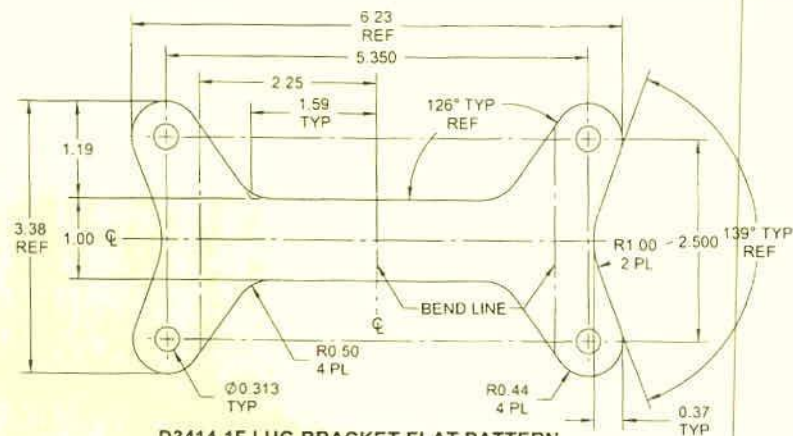


D3414-041 LUG ASSEMBLY

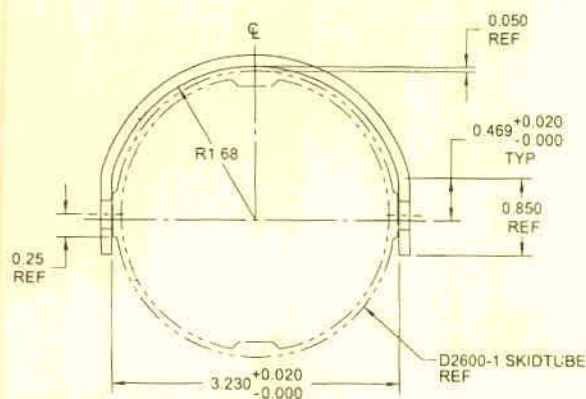


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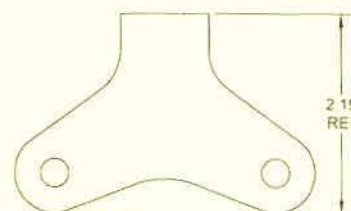
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		LUG ASSEMBLY	N'S
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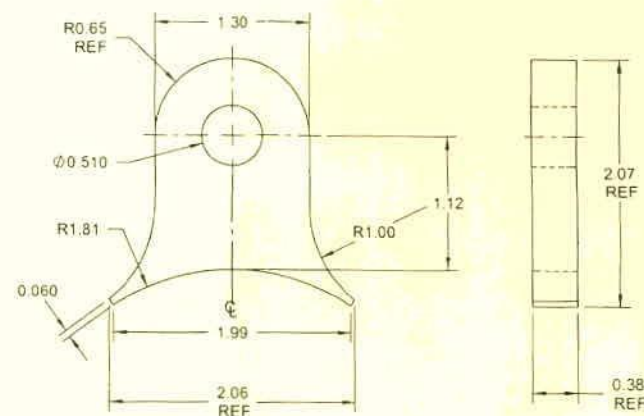
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



RELEASED
29/06/17

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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